

Work Order ID 75867***75867***

Page 1

Thursday, November 17, 2011 4:13:00 PM

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Skidtube 206
Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: 11-17 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| DSI 9583 | A |
| K10111 | B |

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP K10111 CHG003
FOR D206-642-111 CHG006 CHG002
FOR D206-642-113 CHG002

512/01/03NA CK 12/01/05

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 11-12-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 75867***75867***

Page 2

Thursday, November 17, 2011 4:13:00 PM

Item ID: K10111 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Skidtube 206
Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|-----------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC4- 100% Inspect kits for completeness | 0.00 | | | | | | | |
| *120* | | 0.00 | | 512/01/03 | | (X4) | | | |
| QC | Memo | | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | Packaging | 0.00 | | | | | | | |
| *130* | | 0.00 | | 75731 | | | | | |
| Packaging | Memo | | | 75730 | | | | | |
| Packaging | Identify and pack for shipping as per PPP K10111 | | | 76207 | | | | | |
| | PPP D206-642-111 | | | | | | | | |
| | PPP D206-642-113 | | | | | | | | |
| | Location: _____ | | | | | | | | |
| | PPP rev: _____ | | | | | | | | |
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | 0.00 | | | | | | | |
| QC | Memo | | | | | | | | |
| Quality Control | | | | | | | | | |

12/01/03 (X4)

12/01/03 (X4)

CK 12/01/05

MF

12-01-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 17, 2011 4:13:05 PM

Page 1

Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| AN5-10A | | Purchased | No | | | | Each | 872.0000 | | 16 | | | |
| <i>Sy</i> *AN5-10A* | | | | | | | | | ** | <i>Sp</i> | | | |
| Bolt | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST337 | | | | 872 | | | | | |
| | | | | 116704 | | | | 11 | | | | | |
| | | | | 118191 | | | | 59 | | | | | |
| | | | | <u>119547</u> | | | | 802 | | <i>lex</i> | | | |
| AN5-11A | | Purchased | No | | | | Each | 1,599.000 | | 16 | | | |
| <i>Sy</i> *AN5-11A* | | | | | | | | | ** | <i>Sp</i> | | | |
| Bolt | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | ST337 | | | | 21 | | | | | |
| | | | | 117313 | | | | 2 | | | | | |
| | | | | 118191 | | | | 19 | | | | | |
| | | | | ST518 | | | | 1578 | | | | | |
| | | | | <u>119512</u> | | | | 1578 | | | | | |
| AN3-41A | | Purchased | No | | | 110 | Each | 1,655.000 | 8 | 32 | | | |
| <i>Sy</i> *AN3-41A* | | | | | | | | | ** | <i>Sp</i> | | | |
| Bolt | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | |
| | | | | st510 | | | | 1655 | | | | | |
| | | | | <u>119042</u> | | | | 1655 | | <i>32x</i> | | | |

Sp *Q-DI-03*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A Purchased No 110 Each 5,062.000 12 48

AN4-6A

Bolt

**

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

AN4C5A

Purchased

No

110

Each

489.0000

1

4

AN4C5A

BOLT

**

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

AN6-44A

Purchased

No

110

Each

511.0000

2

8

AN6-44A

Bolt

**

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

D206-651-041

CH67001

Manufactured

No

110

Each

1.0000

1

4

D206-651-041

M206A/B GHW

**

Location

Loc Qty

Loc Code

FG125

1

74002

1

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Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110

Each

743.0000

16

64

D2652

Bushing

**

B 73834 SP
2-01-03.

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

D2661-1

Manufactured No

110

Each

18.0000

2

8

D2661-1

Saddle, LH Fwd Aft Out 206

**

B 76748 6x
B 76750 2x SP

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

D2662-1

Manufactured No

110

Each

20.0000

2

8

D2662-1

Saddle, LH In 206

**

B 76784.5x
B 76770 1x
B 76782 2x
SP 11-12-23.

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:13:06 PM

Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2712

Manufactured No

110

Each

2,551.000

10

40

**

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

Manufactured No

110

Each

100.0000

2

8

**

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

Manufactured No

110

Each

126.0000

2

8

**

D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

40X

B76751 SP.

8x

B76752 6x

SP 11-12-23.

2x.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

^D3413-1

Manufactured No

110

Each

94.0000

1

4

D3413-1

Ring

**

SP

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

4x

ST473

2

71041

2

-- MS21042L3

Purchased

No

110

Each

8,781.000

8

32

MS21042L3

Nut

**

SP 11-12-23

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2526

119075

2526

32x

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 17, 2011 4:13:06 PM

Page 6

Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4 Purchased No

110 Each 11,520.00 12 48

MS21042L 4

Nut

**

SP

Location Loc Qty Loc Code

ST300 558

117441 51

117601 374

118451 133

ST516 5962

119017 5962

ST518 5000

119075 5000

18x

MS21042L6 Purchased No

110 Each 1,484.000 2 8

MS21042L 6

Nut

**

SP

Location Loc Qty Loc Code

ST300 484

117677 25

118384 5

118927 48

118968 406

ST518 1000

119075 1000

8x

NAS1149C0463R Purchased No

110 Each 1,379.000 1 4

NAS1149C0463R

Washer

**

SP 11-12-23

Location Loc Qty Loc Code

FP-B 1

115358 1

ST297 1378

117735 378

119097 1000

4x

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,466.000

.8

32

NAS1149D0363.I

Washer

**

SP

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1450

117601

148

118077

1

118612

55

118968

1246

32x

NAS1149D0463J

Purchased

No

110

Each

12,710.00

24

96

NAS1149D0463.I

Washer

**

SP 11-12-23

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12386

119075

10000

119097

2386

96x

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75867

75867

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,153.000

8

32

NAS1149D0563.I

Washer

**

SP

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3153

118206

2153

118614

1000

32x

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4

16

NAS1149D0663.I

Washer

**

SP ~~11-12-23~~

11-12-23

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

16x

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

| AIRCRAFT | INSTALLATION |
|--------------|--------------|
| BELL 206 A/B | D206-642-111 |
| BELL 206 A/B | D206-642-113 |

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

| ITEM | PART NUMBER | K10111 | D206-642-111 | D206-642-113 |
|------|-------------------|--------|--------------|--------------|
| 1 | D206-651-041 | 1 | 1 | 1 |
| 2 | D2652 | 16 | 16 | 16 |
| 3 | D3413-1 | 1 | 1 | 1 |
| 4 | D2661-1 | 2 | 2 | 2 |
| 5 | D2662-1 | 2 | 2 | 2 |
| 6 | D2712 | 10 | 10 | 10 |
| 7 | D2884 | 2 | 2 | 2 |
| 8 | D2885 | 2 | 2 | 2 |
| 9 | AN3-41A | 8 | 8 | 8 |
| 10 | AN4C5A | 1 | 1 | 1 |
| 11 | AN4-6A | 12 | 12 | 12 |
| 12 | AN5-7A | | 8 | |
| 13 | AN5-10A | 4 | | 4 |
| 14 | AN5-11A | 4 | | 4 |
| 15 | AN6-44A | 2 | 2 | 2 |
| 16 | NAS1149D0363J | 8 | 8 | 8 |
| 17 | NAS1149D0463J | 24 | 24 | 24 |
| 18 | NAS1149D0563J | 8 | 8 | 8 |
| 19 | NAS1149D0663J | 4 | 4 | 4 |
| 20 | MS21042-3 (OR L3) | 8 | 8 | 8 |
| 21 | MS21042-4 (OR L4) | 12 | 12 | 12 |
| 22 | MS21042-6 (OR L6) | 2 | 2 | 2 |
| 23 | NAS1149C0463R | 1 | 1 | 1 |

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| B | ADD APPLICABILITY TO D206-642-113 | AJS | 11.09.19 |
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| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. C |
| MFG. APPR. | <i>[Signature]</i> | K10111 | SHEET 1 OF 1 |
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| DE APPR. | <i>[Signature]</i> | SADDLE KIT | NTS |
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